

Work Order ID 101772***101772***

Page 1

May-13-13 1:13:54 PM

Item ID: D2012-115

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Bracket, Clevis

Stop

NS2

Start Date: 5/13/13 Start Qty: 8.00

***8* 9**
8

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan: MUS

Date: 13-05-14

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2012-115	Rev B								
100	Pick Kit PURCHASING	0.00							
100 Packaging Packaging	Memo	0.00							N/A
160	Large Fab	0.00							
160 Large Fab Large Fab	Memo Weld per Dwg D2012-115 Grind flush	0.00							(F9) 226 13.0.10
170	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
170 QC Quality Control	Memo	0.00							(9) B.10.10 DAS 9 9-89

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____		DISPOSITION			AGAINST DEPARTMENT/PROCESS					
		Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
		Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
		Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
		Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear	General									
	<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced					
	<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure					
	<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld					
	<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled					
	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Other					
	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other					
	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Other					
	<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset	<input type="checkbox"/> Other						
	<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Other						
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Other							
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Other							

Work Order ID 101772***101772***

Page 2

May-13-13 1:13:54 PM

Item ID: D2012-115

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket; Clevis

Start Date: 5/13/13 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00							DAS 9 9-89

190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST003</u>	0.00							DAS 28 9-89
	Memo	0.00							13-10-10

200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00							<u>JL/PL</u> 13-10-10
		0.00							

PL 13-10-10

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

Date:

QA Closed: _____ **Date:** _____

Date:

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS									
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other							
Part No. _____															
NCR No. _____															
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector						
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process															
Supplier															
Training															
Unapproved															
FAULT CATEGORY															
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled			

Picklist Print

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Page 1 /

Work Order ID: 101772

Start Date: 5/13/13

Required Date: 5/31/13

Parent Item: D2012-115

Start Qty: 8.00

Required Qty: 8.00

Parent Item Name: Bracket, Clevis

Comments: IPP: A 02.09.20New issueKJ/RF
DD VERF:EC

IPP REV:B 12.05.29 MADE IN HOUSE

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-115-1 L-Bracket		Manufactured	No			100	Each	13.0000	1	1	8	272	13.10.09
B102845 x 5				Location			Loc Qty		Loc Code				
				ST003			13						
				90021			9						
				90537			4				x4		
D2012-115-3 Joggled Bracket		Manufactured	No			100	Each	0.0000	1	1	8	272	13.10.09

B105025 x 9

NCR: Yes / No

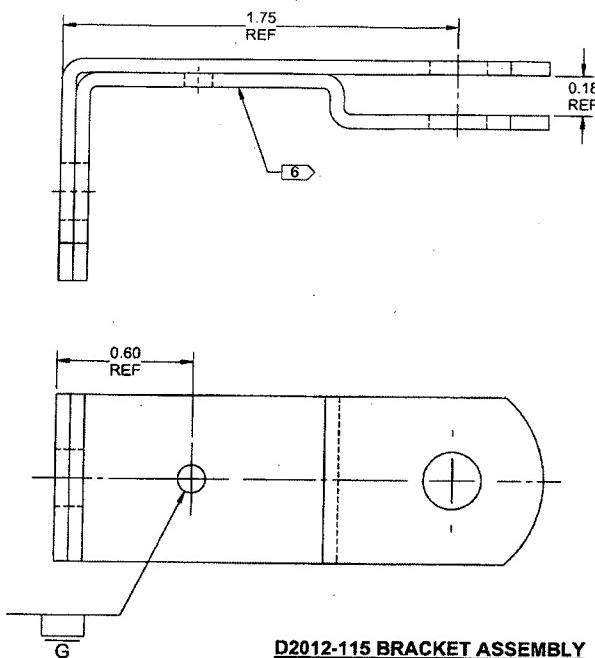
WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

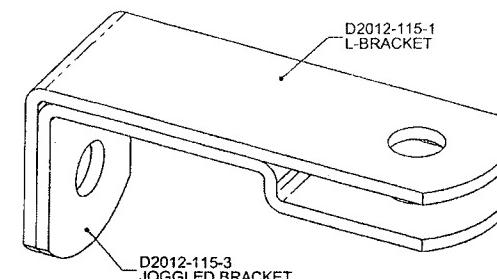
QA Closed: _____ Date: _____

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
				Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	Bend	Grain	Ovalized	Pressure/Forced							
Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure							
Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld							
Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled							
Cuffs	Contamination	Maintenance	Part Moved								
Heat Treat	Countersink	Mislabeled	Positioned Wrong								
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge								
Ripples in Bend	Drill Holes	Offset									
Torque Waves in Extrusion	Drawing	Out of Calibration									
Turning Sequence	Finish	Out of Sequence									
Wave/Twist in Tube	Folio	Outside Dimensions									

ITEM	QTY	P/N	DESCRIPTION
1	X	D2012-115	BRACKET ASSEMBLY
2	1	D2012-115-1	L-BRACKET
3	1	D2012-115-3	JOGGED BRACKET



D2012-115 BRACKET ASSEMBLY



- NOTES:**
- 1) MATERIAL: PER SHEETS 2 AND 3
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2012-115" AND BATCH NUMBER "BXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
 - 7) WEIGHT: 0.08 lbs

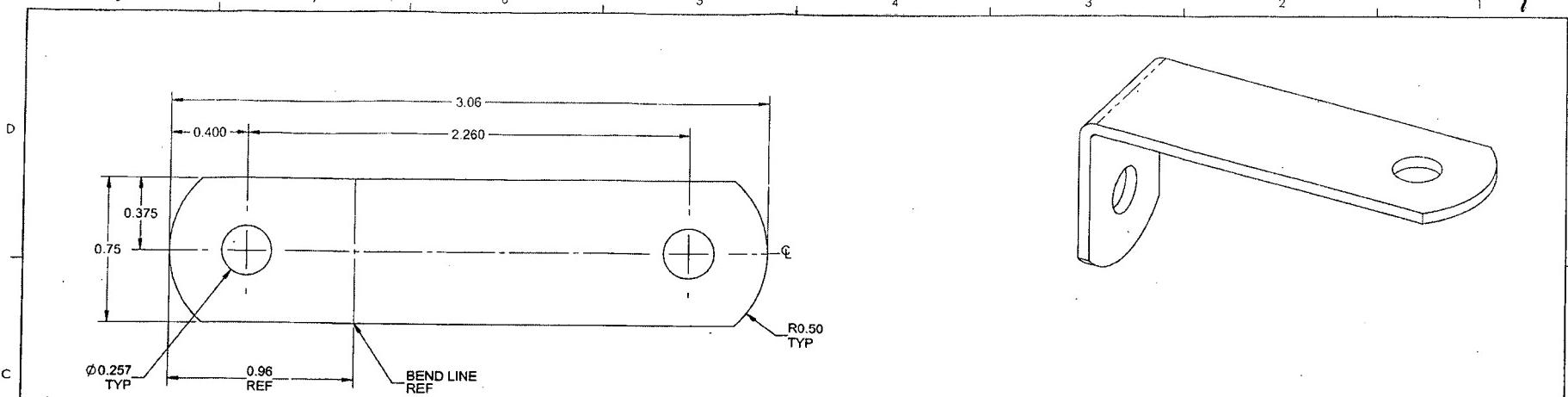
UNCO
SUBJ

101772 M/C

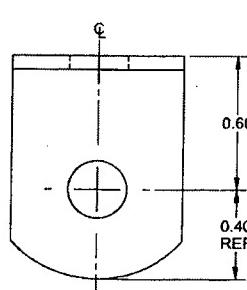
RELEASED
2012-05-28
MP

B	UPDATED TO CURRENT STANDARD FORMAT; ADDITION OF D2012-115-1/15/3/3F. REASON: FACILITATE MANUFACTURING (REF. PAR12-179).		MB	12.04.30
A	NEW ISSUE		SH	92.06.03
REV.	DESCRIPTION		BY	DATE
DESIGN	SH	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED	AS	DRAWING NO.	REV. B	
MFG. APPR.	AM	D2012-115	SHEET 1 OF 3	
APPROVED	MP	TITLE	SCALE	
DE APPR.	MP	BRACKET ASSEMBLY	NTS	
DATE	12.04.30			

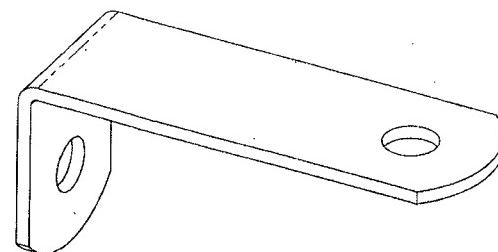
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D2012-115-1F FLAT PATTERN



D2012-115-1 L-BRACKET
(MAKE FROM D2012-115-1F)



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 0.063 THICK, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs

DESIGN	SH	DART AEROSPACE LTD
DRAVN		HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>TS</i>	REV. B
MFG. APPR.		DRAWING NO. D2012-115 SHEET 2 OF 3
APPROVED	<i>MM</i>	TITLE SCALE NTS
DE APPR.	<i>MM</i>	DATE — 12.04.30

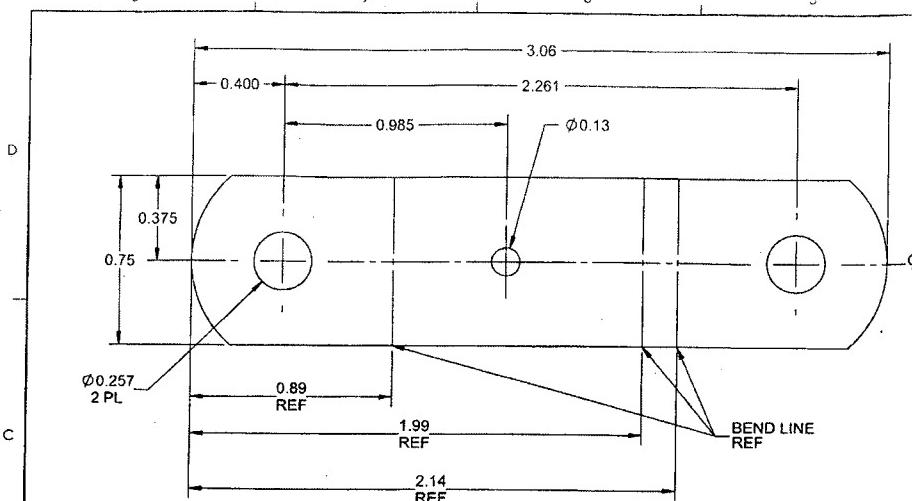
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2012-05-28
MM

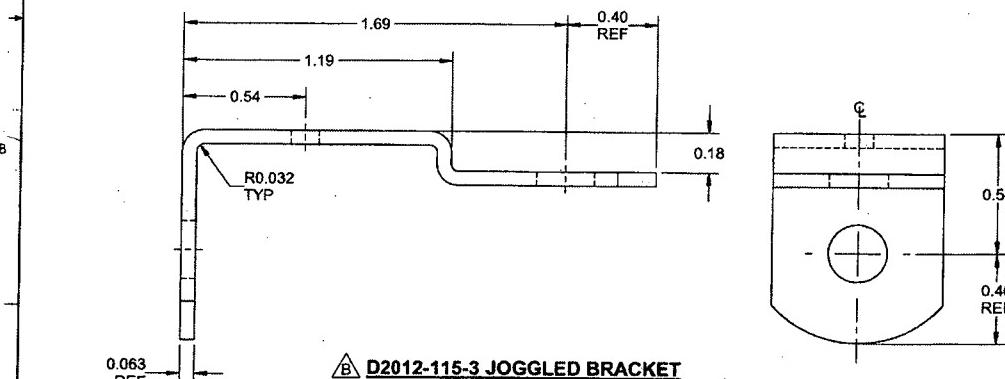
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101772

101722

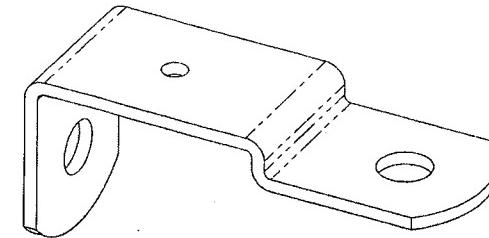


△ D2012-115-3F FLAT PATTERN

△ D2012-115-3 JOGLED BRACKET
(MAKE FROM D2012-115-3F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 0.063 THICK, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs

RELEASED
2012-05-28

DESIGN	SH	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	AS	DRAWING NO.
MFG. APPR.		D2012-115
APPROVED	MM	REV. B
DE APPR.		SHEET 3 OF 3
DATE	12-04-30	SCALE
		NTS
BRACKET ASSEMBLY		

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